

CONTENTS

	PAGE
PREFACE	V
CHAPTER	
I. CHISELS AND FILES	1
II. CUTTING SPEEDS	8
III. TIME FOR MACHINING.	24
IV. SCREW THREADS	34
V. TAPERS	56
VI. THE SPIRAL HEAD	71
VII. TOLERANCES AND ALLOWANCES FOR MACHINE PARTS.	105
VIII. THE USE OF COMMON PRECISION MEASURING DEVICES.	119
IX. PRESS TOOLS.	135
X. TYPICAL STANDARD DIE SETS	152
XI. MACHINE TOOL ANALYSIS	157

EXPERIMENTS

1. HAND TOOLS AND THEIR USE	175
2. THE LATHE	176
3. DRILLING MACHINES	178
4. THE MILLING MACHINE.	181
5. THE SHAPER.	183
6. THE PLANER.	186
7. SMALL TOOLS AND PRECISION MEASURING INSTRUMENTS	187
8. THE SPIRAL HEAD	189
9. GAUGES AND GAUGING.	193
10. PRECISION METHODS OF LOCATING HOLES	196

APPENDIX

CUTTING SPEEDS.	201
DECIMAL EQUIVALENTS	202

CHARTS FOR MILLING CUTTER FEEDS AND SPEEDS.

A.S.M.E. STANDARDS FOR METAL FITS	214
TABLE MEDIUM-FIT TOLERANCES AND ALLOWANCES, AMERICAN STANDARD.	218
TABLE COARSE-THREAD SERIES—MEDIUM FIT SCREW SIZES.	219
TABLE COARSE-THREAD SERIES—MEDIUM FIT NUT SIZES.	220
TABLE COARSE-THREAD SERIES—CLOSE FIT SCREW SIZES.	221
GAUGES.	222
INSTRUCTIONS FOR GRINDING TWIST DRILLS.	226
BLANKING-DIE DATA	229
RULES FOR LAYING OUT BENDING DIES.	234
TYPICAL DRAWING DIES FOR SHEET METAL.	238
TYPICAL DIE SETS	241
RULES FOR CALCULATING SPUR GEARS	243
INDEX	245